

This model was tested with **PLA material**.

To avoid printing problems, we recommend the following settings:

Layer height

Layer height: 0.1 mm

First layer height: 90%

Vertical shells

Perimeters: 2

Horizontal shells

Solid layers:

Top: 8

Bottom: 5

Quality

Detect thin walls: Check

Detect bridging perimeters: Check

Advanced

Seam position: Random

Infill

Fill density: 20%

Fill pattern: Honeycomb

Top/bottom fill pattern: Rectilinear

Reducing printing time

Combine infill every: 1 layers

Advanced

Solid infill every: 0 layers

Fill angle: 25 deg

Solid infill threshold area: 0mm

Skirt

Loops: 2

Distance from object: 6 mm

Skirt height: 1 layers

Minimum extrusion length: 4 mm

Brim

Brim width: 10 mm

Support material

Generate support material: Check

Overhang threshold: 45 deg

Enforce support for the first: 3 layers

Raft

Raft layers: 0 layers

Options for support material and raft

Contact Z distance: 0.1 mm

Pattern: Rectilinear
Patter spacing: 2 mm
Pattern angle: 0 deg
Interface layers: 2 layers
Interface pattern spacing: 0.2 mm

Speed for print moves

Perimeters: 60 mm/s
Small perimeters: 20 mm/s
External perimeters: 20 mm/s
Infill: 60 mm/s
Solid infill: 60 mm/s
Top solid infill: 30 mm/s
Support material: 50 mm/s
Support material interface: 100%
Bridges: 30 mm/s
Gap fill: 50 mm/s

Speed for non-print moves

Travel: 60 mm/s

Modifiers

First layer speed: 30 mm/s

Acceleration control

Perimeters: 800 mm/s
Infill: 1500 mm/s
Bridge: 1000 mm/s
First layer: 1000 mm/s
Default: 1000 mm/s

Autospeed

Max print speed: 100 mm/s
Max volumetrix speed: 0 mm/s

Extrusion width

Default extrusion width: 0.42 mm
First layer: 0.42 mm
Perimeters: 0.42 mm
External perimeters: 0.42 mm
Infill: 0.42 mm
Solid infill: 0.42 mm
Top solid infill: 0.42 mm
Support material: 0.42 mm

Overlap

Infill/Perimeters overlap: 20%

Flow

Bridge flow ratio: 0.95

Other

XY Size Compensation: 0 mm

Threds: 8

Resolution: 0 mm